

Date: Monday, 12/12/2005 7:15:28 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SUPPORT
<b>Job Number</b> :	25200		
<b>Estimate Number</b> :	11336		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D31691
<b>This Issue</b> :	12/12/2005	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3169 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	N/A	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	N/A
	MACHINED PARTS	<b>Due Date</b> :	12/19/2005
<b>Written By</b> :	<i>See comment below</i>		<b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>See comment below</i>		
<b>Comment</b> :	Est Rev:A 02.10.17 New issue KJ		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0625X02500	6061-T6 Bar .625" x 2.5"
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**Comment:** Qty.: 0.3360 f(s)/Unit Total : 3.3600 f(s)

Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8 or QQ-A-250/11) (M6061T6B0.625x02.500)

Batch: *MIS 119*

*EP 05/12/15 10*

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 3.850" x 2.50" x 0.625" thick

*EP 05/12/15 10*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA283 and Dwg D3169

2-Deburr & Tumble

*EP 05/12/15 10*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*EP 05/12/15 10*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*J-L 05.12.15 10*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/12/2005 7:15:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 25200

Part Number: D31691

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 88

10 05/12/16 (10)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21


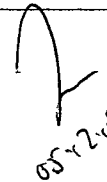


Sur 05/12/20 (10) DP 05/12/20 (10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

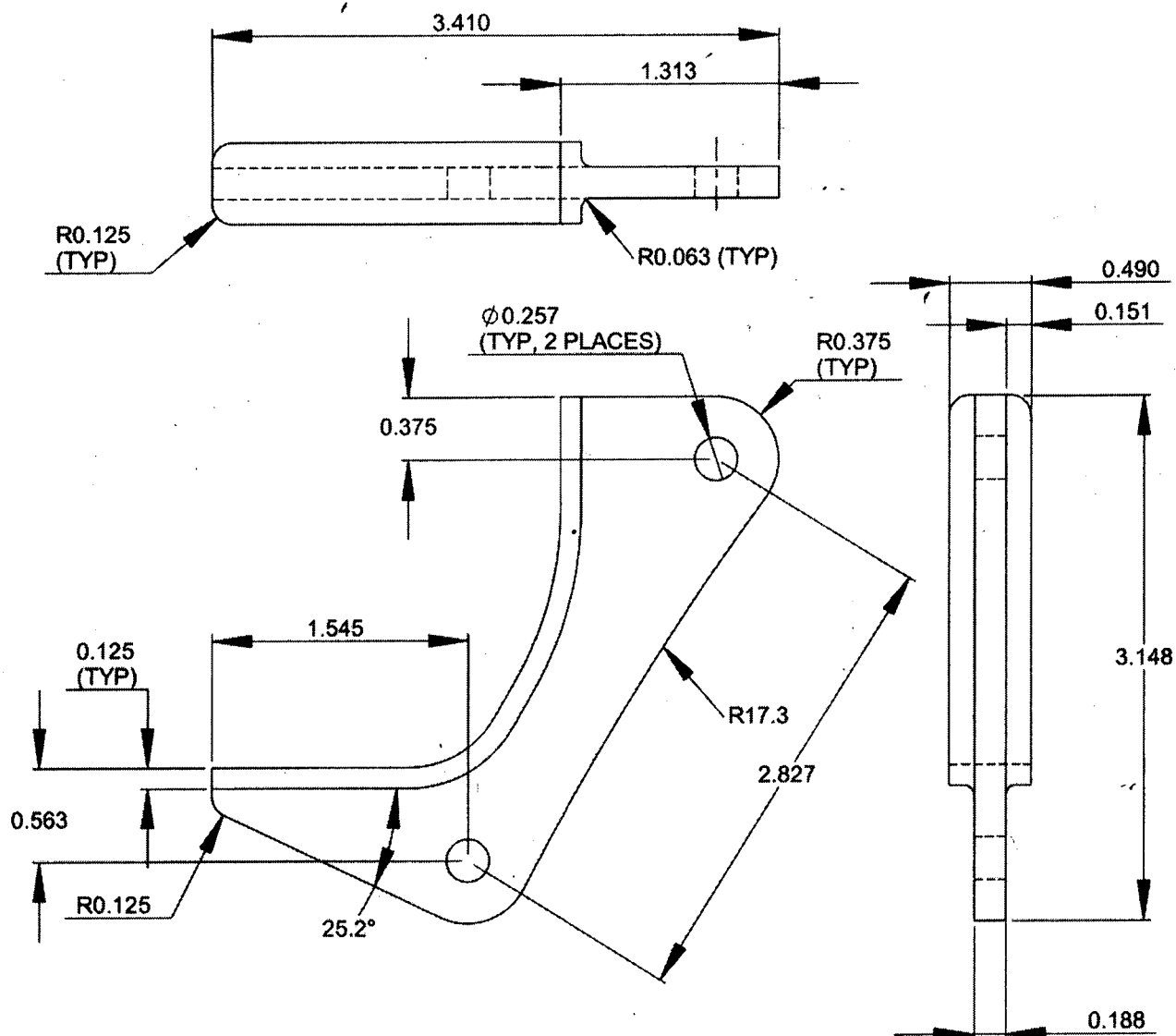
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/15	#30	one part scrap. Part now lifted in vies		Scrap and Destroy and Replace	SP 05/12/15	 05-12-15		 05-12-15

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3169	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SUPPORT	SCALE 1:1
A	-02.09.11	NEW ISSUE	

RELEASED  
02.09.2014



## D3169-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3169-1.SLDPRT"  
2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)  
(REF DART SPEC M6061T6B OR M6061T6S)  
3) FINISH: NONE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.015  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.  
6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

